

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-004016**Date Inspected:** 10-Sep-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1500**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Li Yang/Guo Yan Fei,Li Yan Hua			CWI Present:	Yes	No	
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A
Bridge No:	34-0006			Component:	tower skin assemblies,deck panels		

Summary of Items Observed:

Tower shop - Bay 1

QA Inspector randomly observed approximately 60 ZPMC workers performing the following: flame heat straightening of plates; preheat check by ABF QC Ma Zheng Xi and begin welds NSD1-SA76G/H-10B(CJP) and 4(PJP); SMAW installation of run-off tabs at SSD1-SA171A/D-7A; FCAW-G, manual and automatic with gantry, of stiffener to SSD1-skin C assembly; grinding of stiffener to SSD1-B cover pass in the tilted up position; flame heat straightening of stiffeners on SSD1-skin A assembly. Also present in this bay were ZPMC CWI Li Yang as well as ABF QC's Yang Yi Heng and Zhang Qin Jian. Items observed appeared to comply with project specifications.

Tower shop - Bay 2

QA Inspector randomly observed approximately 35 ZPMC workers performing the following: application of electric heating pads in preparation for second repair of ESD1 stiffeners to skin A assembly; FCAW-G manual of stiffener to ESD1-skin D fill pass. Also present in this bay were ZPMC CWI Guo Yan Fei and ABF QC Zhang Da Ming. Items observed appeared to comply with project specifications.

Heavy Duty Machine Shop – Bay 3

QA Inspector randomly observed 15 ZPMC workers performing the following: grinding of U-rib to deck panel welds on DP553-001, DP567-001, and DP609-001. There were 20 full size panels and 2 half size panels present in the bay.

QA Inspector performed final VT on DP546-001, DP561-001, and DP601-001 with ZPMC CWI Li Yan Hua and ABF QC Wang Zhong Yuan. All three concurred on apparent indications.

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Also present in this bay were ZPMC QC Sun Yan Fei and ABF QC Ding Bao Hua. Items observed appeared to comply with project specification.



Summary of Conversations:

No significant conversations this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Joshua Ishibashi, 136-6471-0411, who represents the Office of Structural Materials for your project.

Inspected By:	Goulet, George
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Quality Assurance Inspector

Reviewed By:	Carreon, Albert
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QA Reviewer
